



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 180459



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 9/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/6/18	9/6/18	0.00	0.00	Start Up Large Fab-4		CPC
110	Large Fab	10 pcs	9/6/18	9/6/18	0.00	9.91	Large Fab 2		CPC
120	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC9		SLY
130	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC5		SLY
140	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.84	HandFinish1		DR 18/08/28
150	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC7-2		10 18-08-28
180	Large Fab	10 pcs	9/6/18	9/6/18	0.00	9.91	Large Fab 2		SLY
190	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC10		SLY
200	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC5		SLY
210	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.84	HandFinish1		SA 18-08-31
220	Powdercoat	10 pcs	9/6/18	9/6/18	0.00	2.90	Powdercoat1		BR 18-9-21
230	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.84	HandFinish3		SLY
240	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC3		SEP 05 2018 68
250	Packaging	10 pcs	9/6/18	9/6/18	0.00	0.00	Packaging1-3		9-89
260	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC4		9-89
270	Packaging	10 pcs	9/6/18	9/6/18	0.00	0.00	Packaging3-1		9-89
275	DC	10 pcs	9/6/18	9/6/18	0.00	0.00	DC		9-89
280	QC21-FG	10 Ea	9/6/18	9/6/18	0.00	0.00	QC21		18-09-10

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138795 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 1:35 OVEN TEMPERATURE: 350 FINISH TIME: 2:05

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5090880
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	51022510

D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	133	0
	D3219-1	20	123	0
	D3272-1	10	25	0
180-Large Fab	D3065-041	10	18	0
	D3066-1	20	178	0
250-Packaging	MS20600-AD4W4	160	3,204	0
	AN3-35A	20	380	0
	AN4-13A	80	2,267	0
	AN5-36A	20	324	0
	D2230-3	40	333	0
	D2618	20	220	0
	D2856-400-720	20	74	0
	D3235-1	20	117	0
	D3278-041	10	42	0
	MS21042L3	20	2,128	0
	MS21042L4	80	3,302	0
	MS21042L5	20	922	0
	NAS1149D0363J	40	1,662	0
	NAS1149D0463J	160	7,409	0
	NAS1149D0563J	40	1,662	0

Part Specifications

Specifications could not be found.

Plex 7/6/18 12:31 PM Dart.lajeunesse.marie



Container No: S104729



Part: D350-591-311

Job No: 180459

Serial No/Batch: S104729

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 1 of 1, FAA STC SH967NE 04/12/21, BRAZIL 1

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Email: sales@dartaero.com
www.dartaerospace.com

D350-591-311

S104729

REV. B



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D350-591-311
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Priority: Medium

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Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/6/18	9/6/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	10 pcs	9/6/18	9/6/18	0.00	9.91	Large Fab 2		
120	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC9		
130	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC5		
140	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.84	HandFinish1		
150	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC7-2		
180	Large Fab	10 pcs	9/6/18	9/6/18	0.00	9.91	Large Fab 2		
190	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC10		
200	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC5		
210	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.84	HandFinish1		
220	Powdercoat	10 pcs	9/6/18	9/6/18	0.00	2.90	Powdercoat1		
230	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.84	HandFinish3		
240	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC3		
250	Packaging	10 pcs	9/6/18	9/6/18	0.00	0.00	Packaging1-3		
260	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC4		
270	Packaging	10 pcs	9/6/18	9/6/18	0.00	0.00	Packaging3-1		
275	DC	10 pcs	9/6/18	9/6/18	0.00	0.00	DC		
280	QC21-FG	10 Ea	9/6/18	9/6/18	0.00	0.00	QC21		

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Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 3-Grind End Plate flush
180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.
220 - START TIME: OVEN TEMPERATURE: FINISH TIME:
270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084
275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	

D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

5089307
5089302
5083019
5106786
5089916
5088273
5089615
5106503
5089340
5089365
5083541
5068661
5089299
5093773

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	133	0
	D3219-1	20	123	0
	D3272-1	10	25	0
180-Large Fab	D3065-041	10	18	0
	D3066-1	20	178	0
	MS20600-AD4W4	160	3,204	0
250-Packaging	AN3-35A	20	380	0
	AN4-13A	80	2,267	0
	AN5-36A	20	324	0
	D2230-3	40	333	0
	D2618	20	220	0
	D2856-400-720	20	74	0
	D3235-1	20	117	0
	D3278-041	10	42	0
	MS21042L3	20	2,128	0
	MS21042L4	80	3,302	0
	MS21042L5	20	922	0
	NAS1149D0363J	40	1,662	0
	NAS1149D0463J	160	7,409	0
	NAS1149D0563J	40	1,662	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

Container No: S104729



Part: D350-591-311

Job No: 180459

Serial No/Batch: S104729

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 15 FAA STC SH967NE

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Plex 7/6/18 12:31 PM Dart.lajeunesse.marie



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004847	S099222	AN4-13A	Bolt	S089302	OVER003	80
004847	S099199	AN5-36A	Bolt	S083019	ST336	20
004847	S099251	D2618	Bushing	S089996	ST012A	20
004847	S099252	D2856-400-720	Abrasion Strip 4" X 7.20"	S098273	ST418	20
004847	S099245	D3235-1	Mounting Lug	S089615	ST522	20
004847	S099189	MS21042L3	Nut	s089340	ST303	20
004847	S099109	NAS1149D0463J	Washer	s089299	ST263	160
004847	S099069	NAS1149D0563J	Washer	s093773	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 8/3/18 2:25 PM Dart,joly,jocelyne

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200
Fax 613 632-5246

Material Trace Report

Container No	Part No	Operation	Quantity	Weight	Add Date	Location	Status	Update Date	Active
S104729	D350-591-311	QC21-FG	10	0	8/23/18	FG084	Stock	9/10/18	✓
S070426	D3219-1	QC21-SA	0	0	5/11/18	Start Up Large Fab-4	Allocated	8/23/18	
S099069	NAS1149D0563J	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099109	NAS1149D0463J	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099163	MS21042L4	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099164	MS21042L5	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099165	NAS1149D0363J	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099189	MS21042L3	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099199	AN5-36A	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099222	AN4-13A	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099245	D3235-1	QC21-SA	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099251	D2618	QC21-SA	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099252	D2856-400-720	QC21-SA	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S104327	D3272-1	QC21-SA	0	0	8/22/18	Start Up Large Fab-4	Allocated	8/23/18	
S104727	D3067-1	QC21-SA	0	0	8/23/18	Start Up Large Fab-4	Allocated	8/23/18	
S104728	D3219-1	QC21-SA	0	0	8/23/18	Start Up Large Fab-4	Allocated	8/23/18	
S106297	D3065-041	QC21-SA	0	0	8/29/18	Large Fab 2	Allocated	8/29/18	
S106299	D3066-1	QC21-SA	0	0	8/29/18	Large Fab 2	Allocated	8/29/18	
S106301	MS20600-AD4W4	Receive Ea	0	0	8/29/18	Large Fab 2	Allocated	8/29/18	
S108237	D2230-3	QC21-SA	0	0	9/5/18	Packaging1-3	Allocated	9/10/18	
S108769	D3278-041	QC21-SA	0	0	9/10/18	Packaging1-3	Allocated	9/10/18	
S108779	AN3-35A	Receive Ea	0	0	9/10/18	Packaging1-3	Allocated	9/10/18	
21 Containers			.00	.00					
21 Containers Total			.00	.00					

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]